

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010535**Date Inspected:** 27-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

CWI Inspector: Mr. Du Zhiqun

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

Tower Bay 10

This QA Inspector observed Ms. Pu Xuezheng, stencil 052075 is using flux cored welding procedure WPS-345-FCAW-2G(2F)-Repair to add weld material to extend the length of north tower first lifting bottom plate bearing stiffeners as detailed on critical weld repair TCWR0472-R0. This QA Inspector observed a welding current of approximately 310 amps and 2308 volts. This QA Inspector observed ZPMC QC Inspector Mr. Yuan Hui Gang is monitoring the maximum interpass temperature and additional stiffener welds are not being made until the base metal adjacent to the weld is allowed to cool to a temperature of less than 260 degrees Celsius. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

This QA Inspector observed ZPMC welder Ms. Dong Yuqin, stencil 053116 is using welding WPS-B-T-4332-TC-P5-F to make weld NSTL4-3K/L-082 between north tower lift 4 elevation 143 meters upper diaphragm and a shear plate. This QA Inspector observed a welding current of approximately 225 amps and 24.0 volts and that Ms. Dong Yuqin appears to be certified to make this weld. Items observed on this date appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

generally comply with applicable contract documents.

This QA Inspector observed Ms. Guo Liang, stencil 057247 using flux cored welding process to tack weld temporary gusset plates to the bottom end of north tower lift 1 exterior stiffener plates. These portions of the exterior stiffener plates where the welds are being installed are to be removed at a later time. QA Inspector observed ZPMC personnel using a torch to preheat the base materials prior to welding. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wu Zhen, stencil 040280 is using shielded metal welding process to weld temporary lifting eyes to the upper exterior skin plates on north tower lift 1. This QA Inspector observed a second person is using a torch to preheat the base material where of these welds are to be made. Items observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
